

7638



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBT400221-121
Job Sheet 178360



JL Sump

28

DAS
21
9-88

6/5

SHIR

8-20

Part No: RBT400221-121

Job Qty: 28 ea

Part Name: Gripper



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/30/18

Job Tracking No:

Due Date: 7/9/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBT400221 REV 3A IPP REV A 18.05.29 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	28 Ea	7/9/18	7/9/18	0.00	0.00	Start Up Machining-3		2 18/07/15
96	Waterjet	28 pcs	7/9/18	7/9/18	0.00	9.33	Waterjet 2 OMAX		2 18/07/15
110	Mori Seiki	28 pcs	7/9/18	7/9/18	0.00	14.00	MORI SL2500Y		11
120	QC	28 pcs	7/9/18	7/9/18	0.00	0.00	QC2 Machining-4		11
130	Mori Seiki	28 pcs	7/9/18	7/9/18	0.00	7.00	MORI NV5000-1		3.C.L
140	QC	28 pcs	7/9/18	7/9/18	0.00	0.00	QC2 Machining-4		3.C.L 18-07-30
150	QC	28 pcs	7/9/18	7/9/18	0.00	0.00	QC8 Machining-4		2 18/07/31
180	Outsource	28 pcs	7/9/18	7/9/18	0.00	0.00	Outsource12		11
190	Packaging	28 pcs	7/9/18	7/9/18	0.00	0.00	Packaging2		AUG 08 2018
200	QC	28 pcs	7/9/18	7/9/18	0.00	0.00	QC6		38
210	Packaging	28 pcs	7/9/18	7/9/18	0.00	0.00	Packaging3-1		11
220	QC21-SA	28 Ea	7/9/18	7/9/18	0.00	0.00	QC21		21 AUG 10 2018

Part Op 96 - 1-Cut as per DWG. DWG. Rev: 3A PROG. Rev: 3A 2-Deburr if necessary
 Descriptions: 110 - 1-Machine as per folio FC 214 FOLIO REV: DWG REV: 2-Deburr
 130 - 1-Machine as per folio FC 214 FOLIO REV: DWG REV: 2-Deburr
 180 - Issue P/O to GROUPE ALTECH; PO 040622 Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type 4140 -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140-S-0.375	AISI 4140 Steel Sheet cut to size* 4ft x 4 ft	9.5200 sf (.34 ea)	90-Start up Operation	Solo 9/135

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140-S-0.375	10	48	0

Part Specifications

Specifications could not be found.

Plex 7/5/18 2:16 PM dart.logan.david



Container No: S091831



Part: RBT400221-121

Job No: 178360

Serial No/Batch: S091831

Revision: 3A

Inspector:

Exp Date:

Instructions:

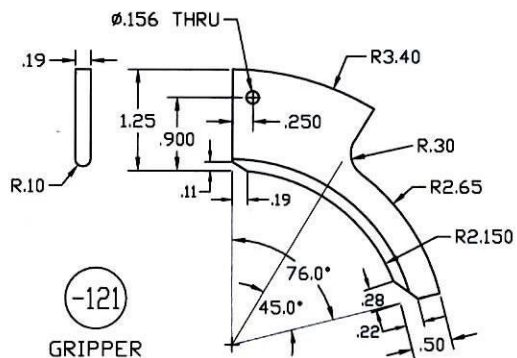
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/15/18

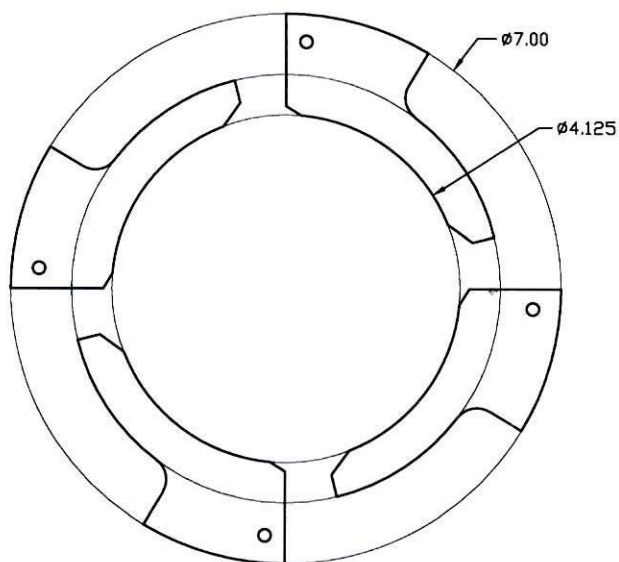
8103 62-1
BC
94 e

This drawing, specifications, and concepts contained herein are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	CH'D BOM P/N -121 MATERIAL FROM STEEL & FROM PLATE TO ROUND, PER D.W., ADDED NOTE SHEET 3 of 3.	11/3/09	RJC	
2	REMOVED GROOVE FROM P/N-109, ADDED NOTE P/N-120A & -120B ASSEMBLY PER R.W.	11/25/09	RJC	



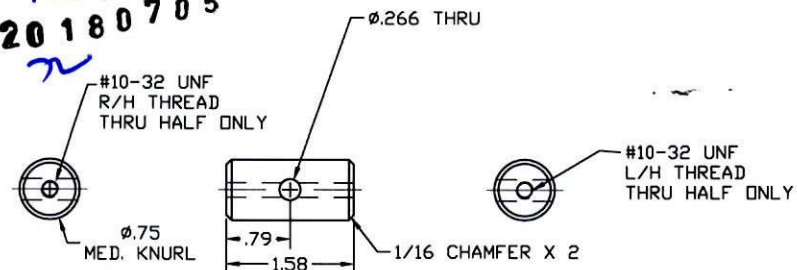
-121
GRIPPER



-109
TURNBUCKLE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 178360

20180705



NOTES:
BUY 7" ROUND 4140 Q&T WATER JET I.D. @ Ø4.125 &
O.D. @ Ø7.00. MACHINE FROM DOUNUT AS SHOWN.

RED BARN MACHINE	
TITLE TOOL - DRIVESHAFT REMOVAL	
DWG NO. RBT400221-109 & -121	REV 3A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ±.005 .XX ±.01 X ±.1	FRACTIONS ± 1/32 ANGLES ±.5°
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 X 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 5-20-02
SHEET 3 of 3	

178360

Page 1 of 1

Caliper

5CL-08

Angle gauge

Caliper

5CL-08

$$18\overline{)107131}$$

Date:

Revised by
KJ

QA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE**DART**
AEROSPACE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																																																	
Description Work Order Deviation			Disposition																																																																		
			Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																																		
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO040662

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO040662

PO Date: 7/31/18

Due Date: 8/6/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	173599	C3-4-4KA	Keeperless Load Beam Assembly - C3 Hook -Issue P/O to Groupe Altech: P/O -Nickel plate, QQ-N-290, Class 2, Grade C -Nickel Plate .0009-.0011 -Certificate of Conformity is required	Firmed	-	8/6/18	5 pcs	0 pcs	5 pcs	\$17.142857/pcs	\$85.71
Line Item Note ** rush **											
2	177402	C2-OH	C-Series Remote Hook 2,000 lbs Lift Capacity -Nickel plate, QQ-N-290, Class 2, Grade E or F - Nickel Plate .0004-.0006 -Bake after plating -Certificate of Conformity is required c2-4-4a: NICKEL PLATE .0009 - .0011 THICK C2-12-3: NICKEL PLATE .0004-.0006	Firmed	-	8/6/18	2 pcs	0 pcs	2 pcs	\$77.14286/pcs	\$154.29

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	178360	RBT400221-121	Gripper -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MIL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type 4140 -Certificate of Conformity is required	Firmed	-	8/6/18	28 pcs	0 pcs	28 pcs	\$3.07692/pcs	\$86.15
							28x	AUG 08 2018			
4	173915	RBE350A94-2708-01-15	Rod Assembly -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4 -Certificate of Conformity is required	Firmed	-	8/6/18	5 pcs	0 pcs	5 pcs	\$3.07692/pcs	\$15.38
							5x	AUG 08 2018			
5	180110	RBE350A94-2706-00-05	Pin -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/6/18	6 pcs	0 pcs	6 pcs	\$3.07692/pcs	\$18.46
							6x	AUG 08 2018			
Line Item Note *urgent *											Grand Total: \$360.00

Order Notes



Certificat de Conformité / Certificate of Compliance

(011480-2)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

011480 - 2

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courrier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
07-Aug-2018		Aman		040662					
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC/ NC Qty		Qté Scrap/	À venir/ Back Order
3	RBT400221-121 ✓ Rev.	RBT400221-121 01-OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS1 WIPE OFF EXCESS OIL MATERIAL 4140	OXIDE-BLACK CH	28	28 ✓	0	0	0	0
4	RBE350A94-2708-01-15 ✓ Rev.	RBE350A94-2708-01-15 01-OXIDE BLACK [OXIDE BLACK] MIL-C-13964C, CLASS 1 MIL-C-16173 GRADE 4	OXIDE-BLACK CH	5	5 ✓	0	0	0	0
5	RBE350A94-2706-00-05 ✓ Rev.	RBE350A94-2706-00-05 01-OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	6	6 ✓	0	0	0	0

Notes Additionnelles / Additional Notes

Épaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.